

# Work Order ID 75840

**\*75840\***

Page 1

November-01-11 11:40:55 AM

Item ID: K10111 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Skidtube 206  
 Start Date: 01/11/2011 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 11/11/2011 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
K10111	B								

100 DOCUMENT CONTROL 0.00  
**\*100\***  
 DC Memo 0.00 CHG003  
 Document Control Photocopy bluefile & type labels per PPP K10111 CHG002  
 FOR D206-642-111 CHG001 1  
 FOR D206-642-113 CHG001 2  
Sulu/17  
MLJ 11-11-8

110 Pick Kit 0.00  
**\*110\***  
 Packaging Memo 0.00  
 Packaging  
SP 11-11-10.

120 QC4- 100% Inspect kits for completeness 0.00  
**\*120\***  
 QC Memo 0.00  
 Quality Control  
Sulu/17  
(TS)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 75840****\*75840\***

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Item ID: K10111

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 11/11/2011 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP	K10111							
	PPP D206-642-111								
	PPP D206-642-113								
	Location: _____								
	PPP rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

SP 11-11-17

11/11/17

R 11-11-17  
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 1

Work Order ID: 75840

**\*75840\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: F01.11.08 Revised Step 5 and Added Inspection Level  
21SM IPP REV:G  
11.09.23 PER REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-41A		Purchased	No			110	Each	1,975.000	8	40			
<b>*AN3-41A*</b>									**				

Location	Loc Qty	Loc Code
ST354	16	
118112	16	
st510	1959	
119042	1959	

AN4-6A		Purchased	No			110	Each	5,788.000	12	60			
<b>*AN4-6A*</b>									**				

Location	Loc Qty	Loc Code
ST356	788	
116924	8	
117514	6	
118628	274	
118838	300	
119127	200	

ST516	5000	
119017	5000	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 75840

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Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

AN4C5A

Purchased

No

110

Each

529.0000

\*\*

5

**\*AN4C5A\***

BOLT

Location

Loc Qty

Loc Code

FP-B

54

112243

54

ST345

2

112243

2

ST355

473

112243

373

119017

100

110

Each

2,841.000

\*\*

AN5-7A

Purchased

No

**\*AN5-7A\***

Bolt

Location

Loc Qty

Loc Code

ST337

15

117313

14

118422

1

ST516

2826

119017

2826

110

Each

591.0000

\*\*

2

10

AN6-44A

Purchased

No

**\*AN6-44A\***

Bolt

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

584

119036

584

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

D206-651-041

CHC7001

Manufactured No

110

Each

41.0000

1 5

\*\*

SP

**\*D206-651-041\***

206A/B GHW

Location

Loc Qty

Loc Code

FG

17

74002

17

5X

FG125

24

74001

24

Manufactured No

110

Each

159.0000

16 80

\*\*

B 73836 SP

**\*D2652\***

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

115

73833

115

Manufactured No

110

Each

48.0000

2 110 SP

\*\* B76510

D2661-1

**\*D2661-1\***

Saddle, LH Fwd Aft Out 206

Location

Loc Qty

Loc Code

ST435

30

73839

10

73841

10

74352

20

ST476

18

73840

8

B 74474 SP

74352 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

D2662-1

Manufactured No

110

Each

12.0000

**\*\*** 2 10

**\*D2662-1\***

Saddle, LH In 206

B74357 2x SP  
B74479 1x

Location

Loc Qty

Loc Code

ST435

12

64557

6

73846

4

73849

2

Manufactured No

110

Each

951.0000

**\*\*** 10 50

D2712

**\*D2712\***

Set Screw

SP

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

901

71160

1

73837

900

Manufactured No

110

Each

180.0000

**\*\*** 2 10

D2884

**\*D2884\***

Saddle Spacer

50x

SP 11-11-10

Location

Loc Qty

Loc Code

FG

10

29453

10

ST025

170

73823

170

10x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

D2885

Manufactured No

110

Each

206.0000

2 10

\*\*

SP

**\*D2885\***

Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29199

10

ST025

196

73824

196

10X

D3413-1

Manufactured No

110

Each

46.0000

1 5

\*\*

SP 11-11-10

**\*D3413-1\***

Ring

Location

Loc Qty

Loc Code

ST368

41

73821

41

5A

ST420

2

66387

1

70773

1

ST467

1

73298

1

ST473

2

71041

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 75840

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Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L3 Purchased No 110 Each 9,776.000 8 40  
**\*MS21042I 3\***  
 Nut

Location Loc Qty Loc Code

ST300 776  
 117441 16  
 117885 42  
 118451 90  
 118927 628

ST516 6000  
 119017 6000

ST518 3000  
 119075 3000

MS21042L4 Purchased No 110 Each 13,239.00 12 60  
**\*MS21042I 4\***  
 Nut

Location Loc Qty Loc Code

ST300 2239  
 117441 51  
 117601 532  
 118451 656  
 118927 1000

ST516 6000  
 119017 6000

ST518 5000  
 119075 5000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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November-01-11 11:40:59 AM

Work Order ID: 75840

**\*75840\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L6

Purchased

No

110

Each

1,672.000

2 10

**\*MS21042L6\***

Nut

Location

Loc Qty

Loc Code

ST300

672

117677

25

118384

5

118927

48

118968

594

ST518

1000

119075

1000

NAS1149C0463R

Purchased

No

110

Each

1,422.000

1 5

**\*NAS1149C0463R\***

Washer

Location

Loc Qty

Loc Code

FP-B

1

115358

1

ST297

1421

117735

421

119097

1000

NAS1149D0363J

Purchased

No

110

Each

2,570.000

8 40

**\*NAS1149D0363J\***

Washer

Location

Loc Qty

Loc Code

ST019

16

117505

16

ST298

2554

117601

213

118077

51

118612

290

118968

2000

November-01-11 11:40:59 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0463J

Purchased

No

110

Each

15,586.00

24

120

**\*NAS1149D0463.I\***

Washer

\*\*

SP

Location

Loc Qty

Loc Code

ST019

25

118179

25

ST298

561

116025

16

116805

0

117291

1

117460

2

118179

35

118384

289

118612

1

119042

217

ST407

15000

119075

10000

119097

5000

NAS1149D0563J

Purchased

No

110

Each

3,803.000

8

40

**\*NAS1149D0563.I\***

Washer

\*\*

SP 11-11-10

Location

Loc Qty

Loc Code

ST298

3803

118206

2803

118614

1000

40 X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 01/11/2011

Required Date: 11/11/2011

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0663J

Purchased

No

110

Each

3,180.000

4

20

**\*NAS1149D0663.J\***

Washer

\*\*

Sp 11-11-10.

Location

Loc Qty

Loc Code

ST298

180

115996

5

117977

1

118614

174

ST407

3000

119075

3000

Box

November-01-11 11:40:59 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-111
BELL 206 A/B	D206-642-113

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10111	D206-642-111	D206-642-113
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-1	2	2	2
5	D2662-1	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-113	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	K10111	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE KIT	NTS
DATE	11.11.10	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

